

ASAP 30/11 12:57

# Work Order ID 53872



November 23, 2009 8:07:58 AM

Item ID:	D3216-1	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Fitting					
Start Date:	23/11/2009	Start Qty: 8.00		Cust Item ID:		
Required Date:	27/11/2009	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09/11/23	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3216	Rev A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3216 □Dwg Rev: <u>A</u> □Prog Rev: <u>A</u> □2- Deburr if necessary								

189-11-24

110	QC2- Inspect parts off machine.FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

189-11-24

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

250611/26

100%

420

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53872

November 23, 2009 8:07:58 AM



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Item ID: D3216-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Fitting

Start Date: 23/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble until parts have a polished finish.

B9-1-27

(25)

Debur = 7 m k out 26

(25X)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) 8 out 130

center

(25)

150

0.00



Identify as per dwg & Stock Location: 75

Packaging

Memo

0.00

Packaging

12/4/30

(25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 53872**

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November 23, 2009 8:07:59 AM

Item ID: D3216-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Fitting

Start Date: 23/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/30

09-11-30

(25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Print

23, 2009 8:08:56 AM

Order ID: 53872  
Item: D3216-1RevA  
Item Name: Fitting

Components:  
Component Item ID/  
Name

04S11GA  
04/316 0.125 Sheet



Start Date: 23/11/2009  
Start Qty: 8.00

Required Date: 27/11/2009  
Required Qty: 8.00

Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
			100	sf	127.2400	0.2425	1.		

B 811-24

25

Warehouse  
Location  
Main Warehouse  
MAT  
112663

Loc Qty

Loc Code

127.24  
127.24

112663

# WORK ORDER CHANGES

W/O:						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 53872
<b>Description:</b> Fitting		<b>Part Number:</b> D3216-1
<b>Inspection Dwg:</b> D3216	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

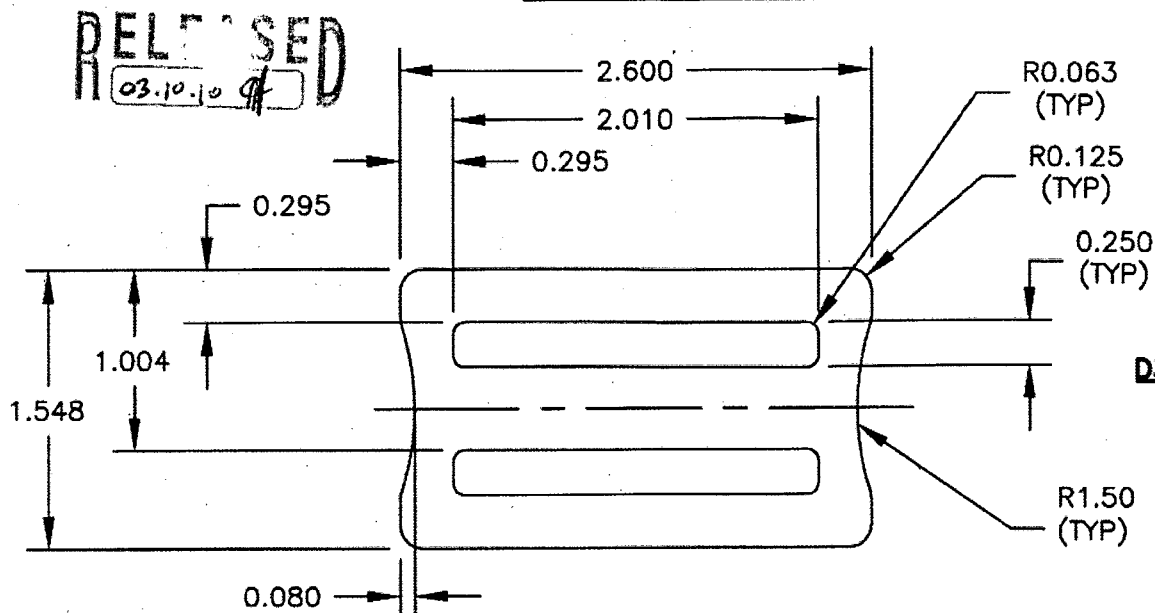
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.600	+/-0.010	2.606	X			
2.010	+/-0.010	2.016	X			
0.295	+/-0.010	0.291	X			
1.548	+/-0.010	1.551	X			
1.004	+/-0.010	1.001	X			
0.295	+/-0.010	0.297	X			
0.250	+/-0.010	0.242	X			
0.125	+/-0.010	0.117	X			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-11-24	<b>Date:</b> 09/11/26	<b>Date:</b>	N/A

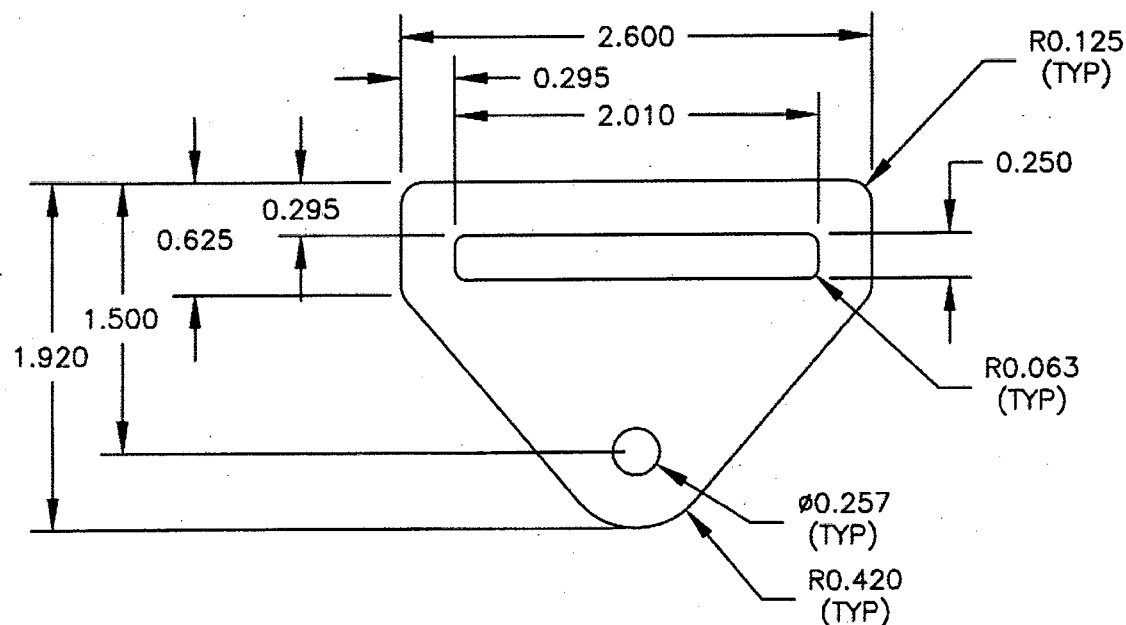
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	[Signature]



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3216	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	



**D3216-1 FITTING**



**D3216-3 FITTING**

**D3216-1/-3 FITTING**

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53572

*BT 09-11-23*

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